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U/R

SAD
18.09.18

D3915-041
Job Sheet 183419



Part No: D3915-041

Job Qty: 1 ea

Part Name: Light Lid Assembly, Long Basket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/18/18

Job Tracking No:

Due Date: 9/28/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: URF 18-737 DWG REV F SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C add realodine DD 10.04.26 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 13.07.08 as per dwg rev.D DD verf.JLM IPP REV:D 13.08.21 DWG REV.E / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	9/28/18	9/28/18	0.00	0.00	Start Up Large Fab-5		2018-09-18
100	Large Fab	1 pcs	9/28/18	9/28/18	0.00	3.33	Large Fab 2		CPL
110	QC	1 pcs	9/28/18	9/28/18	0.00	0.00	QC9		EL
120	QC	1 pcs	9/28/18	9/28/18	0.00	0.00	QC5		EL
130	HandFinish	1 pcs	9/28/18	9/28/18	0.00	1.00	HandFinish1		D.R 18/09/20
140	Large Fab	1 pcs	9/28/18	9/28/18	0.00	3.33	Large Fab 2		CPL
150	QC	1 pcs	9/28/18	9/28/18	0.00	0.00	QC9		EL
155	QC	1 pcs	9/28/18	9/28/18	0.00	0.00	QC5		EL
157	HandFinish	1 pcs	9/28/18	9/28/18	0.00	1.00	HandFinish1		D.R 18/09/25
160	Powdercoat	1 pcs	9/28/18	9/28/18	0.00	0.83	Powdercoat1		18-10-3
170	QC	1 pcs	9/28/18	9/28/18	0.00	0.00	QC3		
180	HandFinish	1 pcs	9/28/18	9/28/18	0.00	0.81	HandFinish4		BEB 19-02-20
190	QC	1 pcs	9/28/18	9/28/18	0.00	0.00	QC5		21
200	Packaging	1 pcs	9/28/18	9/28/18	0.00	0.00	Packaging3-2		21
210	QC21-SA	1 Ea	9/28/18	9/28/18	0.00	0.00	QC21		21

Part Op 100 - 1- assemble ribs , weld as per dwg D3915 using DT9606A. When welding D4019-3, weld top and bottom then make Descriptions: a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld. ****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME**** 2- weld hinge, label plate and Mounting plates as per dwg D3915 120 - -Scribe Dart P/N and B/N as per dwg. Using 0.13 (minimum) high lettering per QSI 044 6.4 130 - ***ENSURE TO RINSE CAREFULLY ACID AND ALODINE*** 140 - 1- weld (4) corners 155 - ***inspect fit of lid with base*** 157 - 1- realodine corners ***do not acid etch*** 160 - 1- touch up corner with alodine only 2- Plug holes prior to finish 3-Mask this area prior to finish View B-B 1ST COAT: START TIME: 10:50 OVEN TEMPERATURE: 320° FINISH TIME: 11:20 ***** 2nd coat if necessary ***** 2ND COAT: START TIME: OVEN TEMPERATURE: FINISH TIME: 180 - 1- Install webbing as per dwg 2- Install placard and label as per dwg

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

D2957	Mounting Plate	4 Ea (4 ea)	90-Start up Operation
D3915-1	Rib	2 Ea (2 ea)	90-Start up Operation
D4016-5	Hinge Half, Light Lid	3 Ea (3 ea)	90-Start up Operation
D4019-3	Rib	3 Ea (3 ea)	90-Start up Operation
D4035-047	Lid Rib Assembly, Aft (Light)	2 Ea (2 ea)	90-Start up Operation
D4056-1	Label Plate	1 Ea (1 ea)	90-Start up Operation
D2728-1	Dart Logo Label Small	1 Ea (1 ea)	180-HandFinish
D4029-041	Webbing (Long Basket)	1 Ea (1 ea)	180-HandFinish
MS20600-AD4W4	Rivet	34 Ea (34 ea)	180-HandFinish
NAS1149DN949J	Washer	34 Ea (34 ea)	180-HandFinish

5083647
5084074
5039258
5084469
5085093
5067108

5149900
5141237
5050054

M. 4. 008219.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2957	4	45	0
	D3915-1	2	4	0
	D4016-5	3	25	0
	D4019-3	3	17	0
	D4035-047	2	4	0
	D4056-1	1	14	0
180-HandFinish	D2728-1	1	0	0
	D4029-041	1	2	0
	MS20600-AD4W4	34	460	0
	NAS1149DN949J	34	269	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

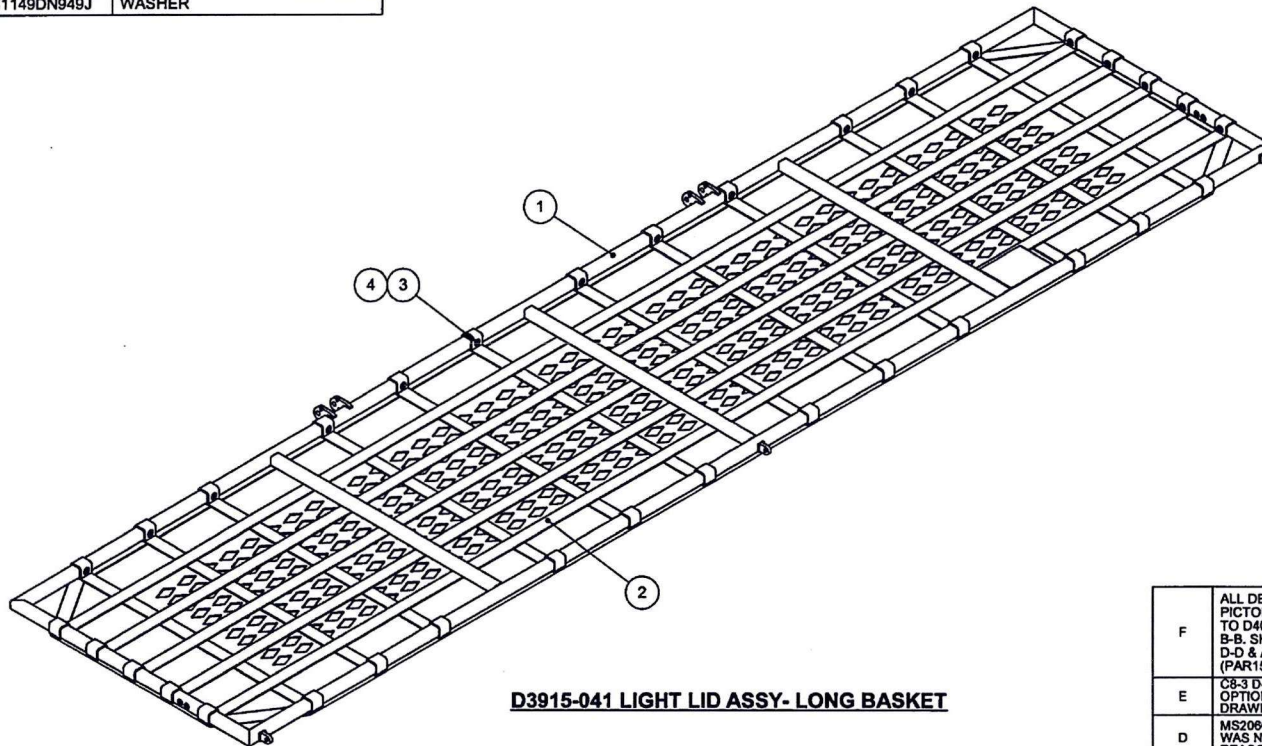
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3915-041	LIGHT LID ASSY-LONG BASKET
1	1	D3915-101	BASKET LID WELDMENT ASSY
2	1	D4029-041	WEBBING (LONG BASKET)
3	34	MS20600AD4W4	RIVET, BLIND, PAN-HEAD
4	34	NAS1149DN949J	WASHER



D3915-041 LIGHT LID ASSY- LONG BASKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 183419 MJS

1809-18

UNDER REVIEW
URF18-737 SAD 18-06-01

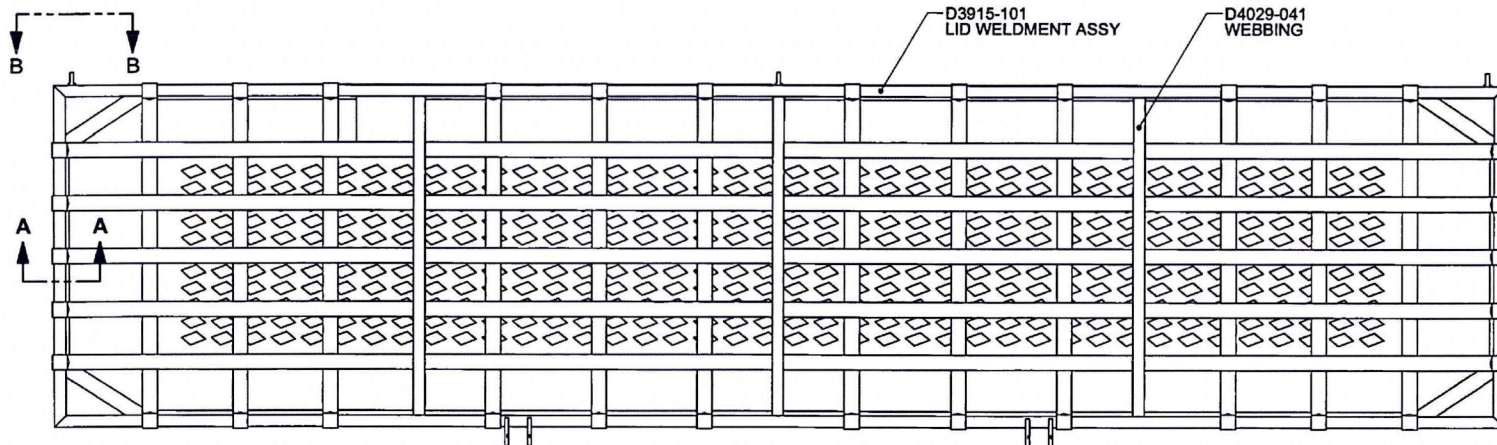
F	ALL DETAIL/SECTION VIEW LETTERS UPDATED. PICTORIAL UPDATES TO SHEETS 1 & 2 FOR UPDATES TO D4029-041. SHEET 1 UPDATED NOTE 6 ADDED VIEW B-B. SHEET 2: D2728-1 DELETED. SHEET 3: ADDED VIEW D-D & ADDED NOTES 9 & 10. WEIGHT UPDATE. (PAR15-418)	AJS	16.11.21
E	C8-3 D4035-047 WAS D4035-045 (REASON PROPRM OPTION REMOVED). SHT 3 DETAIL C DELETED FOR DRAWING CLARITY.	AJS	13.07.18
D	MS20600AD4W4 WAS MS20600AD4W3; NAS1149DN949J WAS NAS1149DN418J (ZN D6-1, C6-1, B1-2). REASON: PAR13-259.	MB	13.06.19
C	REORGANIZED BILL OF MATERIALS: SEPARATED -101 FROM -041 (D6-1, D6-3); REORGANIZED VIEWS ON SHT 3 ACCORDINGLY; REMOVED D4086-220, UPDATED VIEW E ACCORDINGLY (A6-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	MS20600AD4W3 WAS MS20600AD4W5: BOM & (B1-2)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.18
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3915 TITLE LIGHT LID ASSY-LONG BASKET COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	AJS		
CHECKED	JMH		
MFG. APPR.	DD		
APPROVED	WM		
DE APPR.	DS	REV. F SHEET 1 OF 4 SCALE NTS	
DATE	16.11.21		

NOTES:

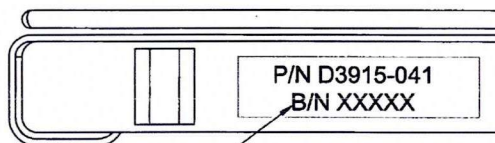
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART P/N AND B/N USING 0.13 (MINIMUM) HIGH LETTERING PER QSI 044 6.4
- 7) WEIGHT: 7.25 lbs (APPROX)

RELEASED
2017-06-07
ECN 17-580

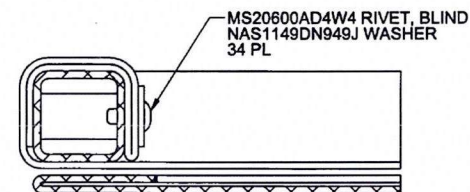
APPROVED



D3915-041 LIGHT LID ASSY- LONG BASKET



VIEW B-B
SCALE: 8X



SECTION A-A
SCALE: 8X

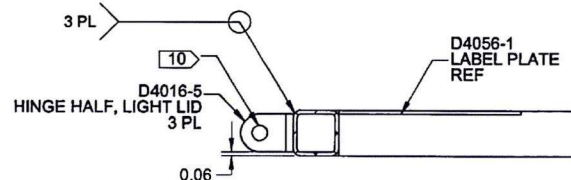
UNDER REVIEW
URF18-737 SAD 18-06-01

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2017-06-07

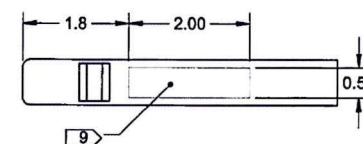
APPROVED

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JMH	DRAWING NO.	REV. F
MFG. APPR.	DD	D3915	SHEET 2 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	LIGHT LID ASSY-LONG BASKET	NTS
DATE	16.11.21	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

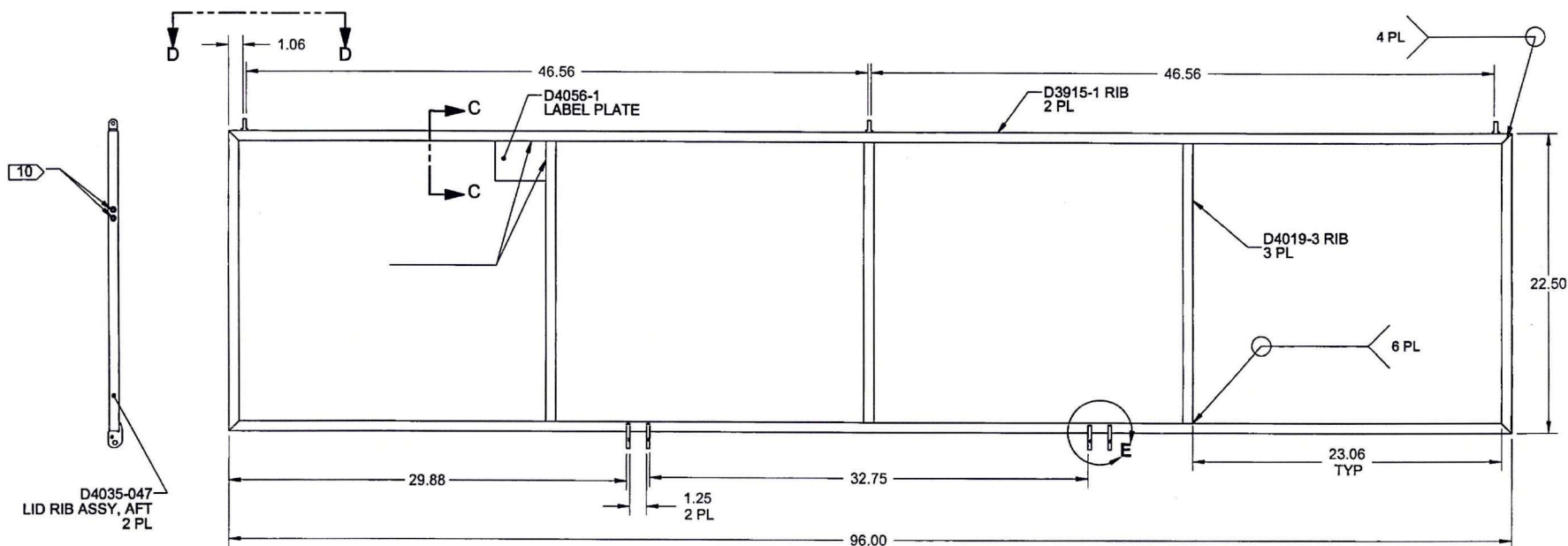
ITEM	QTY	P/N	DESCRIPTION
	X	D3915-101	BASKET LID WELDMENT ASSY
1	2	D3915-1	RIB
2	4	D2957	MOUNTING PLATE
3	3	D4016-5	HINGE HALF, LIGHT LID
4	3	D4019-3	RIB
5	2	D4035-047	BASKET LID RIB ASSY, AFT (LIGHT)
6	1	D4056-1	LABEL PLATE, 350 LIGHT BASKET



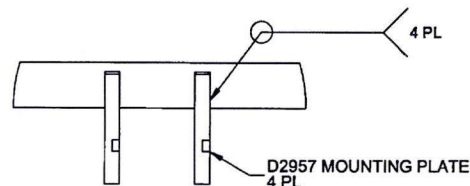
SECTION C-C
SCALE: 4X
ROTATED 90



SECTION D-D
SCALE: 4X



D3915-101 BASKET LID WELDMENT ASSY



DETAIL E
SCALE: 4X

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 4.89 lbs
- 8) WELD PER DART QSI 004
- 9) MASK THIS AREA PRIOR TO POWDER COAT
- 10) MASK HOLES PRIOR TO POWDER COAT

RELEASED
2017-06-07

UNDER REVIEW
URF18-737 SAD 18-06-01

APPROVED

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JMH	DRAWING NO.	REV. F
MFG. APPR.	DD	D3915	SHEET 3 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	LIGHT LID ASSY-LONG BASKET	NTS
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2017-06-07 RELEASED APPROVED

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3915 REV. F SHEET 1 OF 4
DRAWN	AJS	
CHECKED	JMH	
MFG. APPR.	DD	
APPROVED	WM	
DATE	16.11.21	TITLE LIGHT LID ASSY-LONG BASKETS SCALE 1:1 COPYRIGHT © 2016 BY DART AEROSPACE LTD No part of this drawing may be reproduced or transmitted in any form or by any means, electronic or mechanical, including photocopying, recording, or by any information storage and retrieval system, without prior written permission from DART AEROSPACE LTD. THIS DOCUMENT IS UNCLASSIFIED.



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Container No: S111045



Part: D3915-041

Job No: 183419

Serial No/Batch: S111045

Revision: F

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/18/18